

Date: Thursday, 4/12/2007 9:33:03 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	LATCH
Job Number	31777			
Estimate Number	12772			
P.O. Number	N/A		Part Number	41232 200 002 003
This Issue	4/12/2007	S.O. No. N/A	Drawing Number	41232-200-002 REV A
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type MACHINED PARTS	Drawing Revision	A
Previous Run	31020		Material	N/A
Written By			Due Date	5/10/2007
Checked & Approved By			Qty:	8
Comment	Est Rev:A	New Issue 07-03-05 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M2024T3R1875	2024 T3 ROUND BAR 1.875
	Comment: Qty.: 0.3675 f(s)/Unit Total : 2.9400 f(s) 2024-T3 Round Bar 1.250" 1.875 Batch: 10375 17892	
2.0	LATHE CONV HARDINGE	CONVENTIONAL LATHE
	Comment: CONVENTIONAL LATHE Turn as per Dwg 41232-200-0021	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	MILLING CONV. OK.	CONVENTIONAL MILLING MACHINE
	Comment: CONVENTIONAL MILLING MACHINE Mill as per Dwg 41232-200-002	
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
6.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
3.1	HAAS.	
	Mill as per folio fab688.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 05/05/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/04/11	4	part is scrapped - error in new pgm - tool was plumping into the part	070501 051012	- scrap & replace - fix pgm	J.L.	0705-01	051042	0705-01

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:33:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH

Job Number: 31777

Part Number: 41232 200 002 003

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting PURCHASING

Issue P/O: 3680

20/05/02 ⑦

Black Anodize as per Dwg 41232-200-005

Ensure Certificate of Conformity is attached

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

20/05/02 ⑧

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

20/05/02 ⑨

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20/05/02 ⑩

Job Completion



20/05/02 ⑪

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

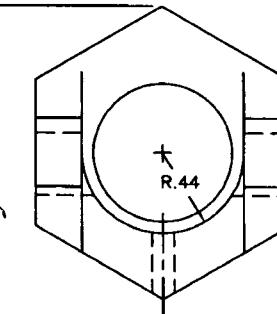
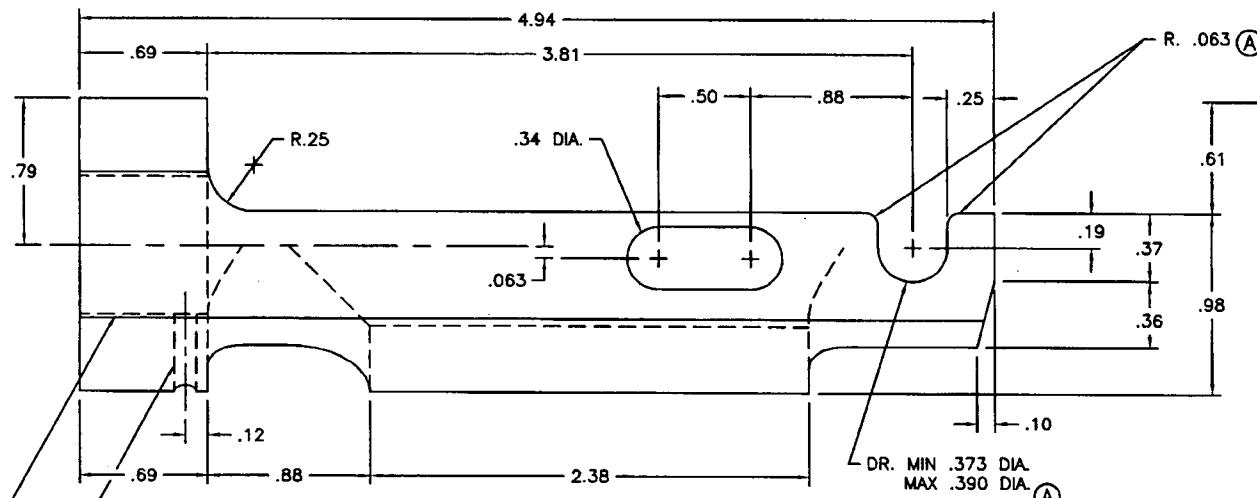
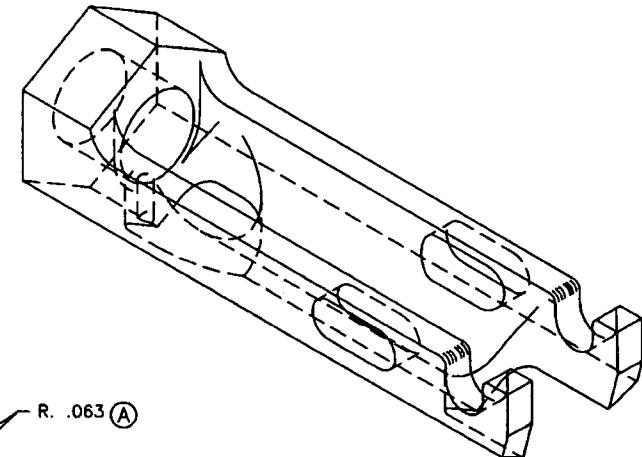
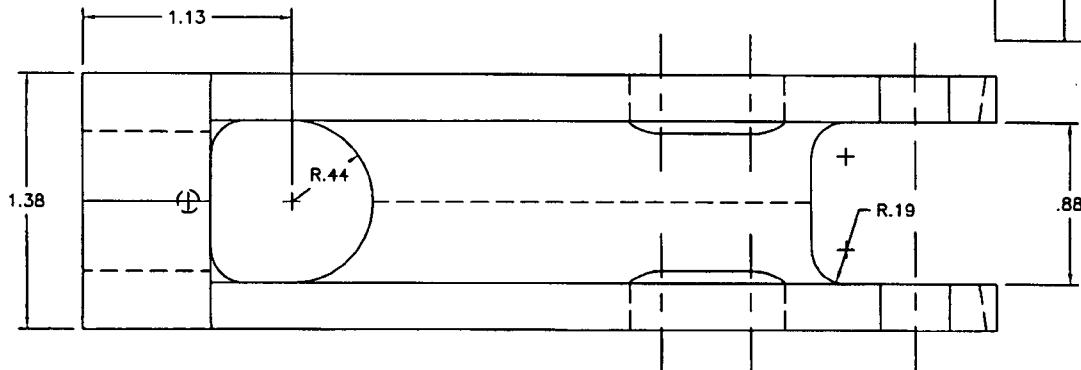
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REVISION					
LETTER	DFTSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	2/17/03	ADDED SMOOTH EDGES TO -001 & -003; REDUCED LENGTH OF -003 BY .125"; ADDED DRAIN HOLE TO -001; INCREASED DIA. OF AFT SLOT ON -001.		
			MINOR CHANGE - FAR 21.95	CHECK	D. MURPHY
					2/17/03



-001 TUBE

— DR. .12 DIA. DRAIN HOLE
(NOTE: SPOTFACE IF REQ'D
TO DRILL HOLE) *15* *7* **(A)**

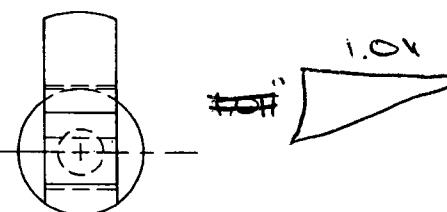
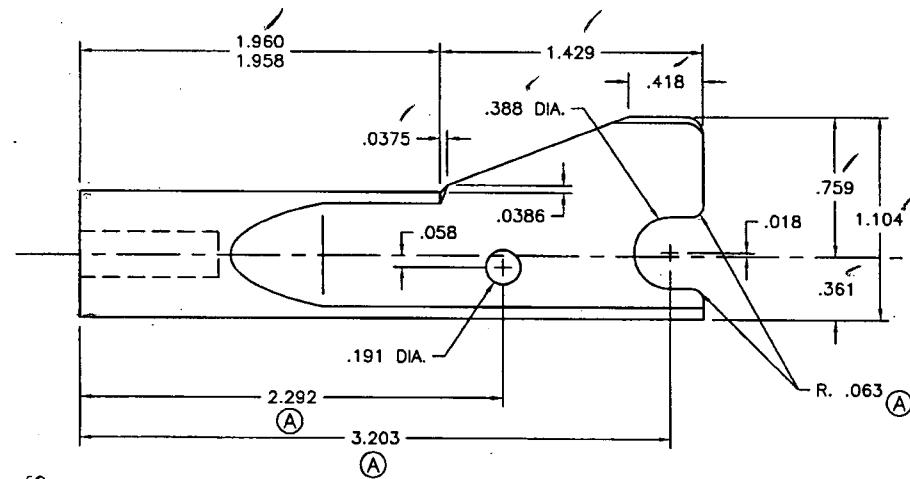
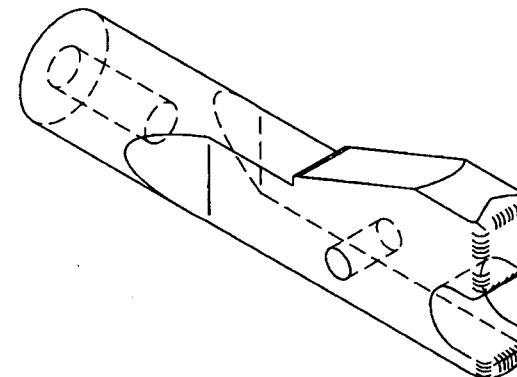
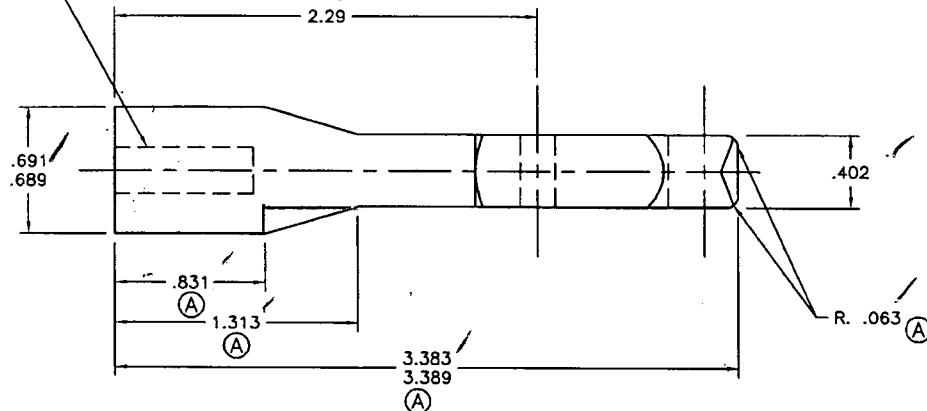
3/4"-20 THD,

10-317-17
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
CONTROLLED COPY
ENGINEERING
RETURN TO

**⚠ ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE III, CLASS 2
DYED BLACK.**

NOTE:

.625 + 1/16 / -000
DRILL DEPTH TO 1.000 MAX
AS NEEDED FOR THREAD.



1003-382

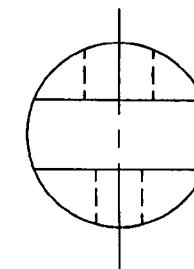
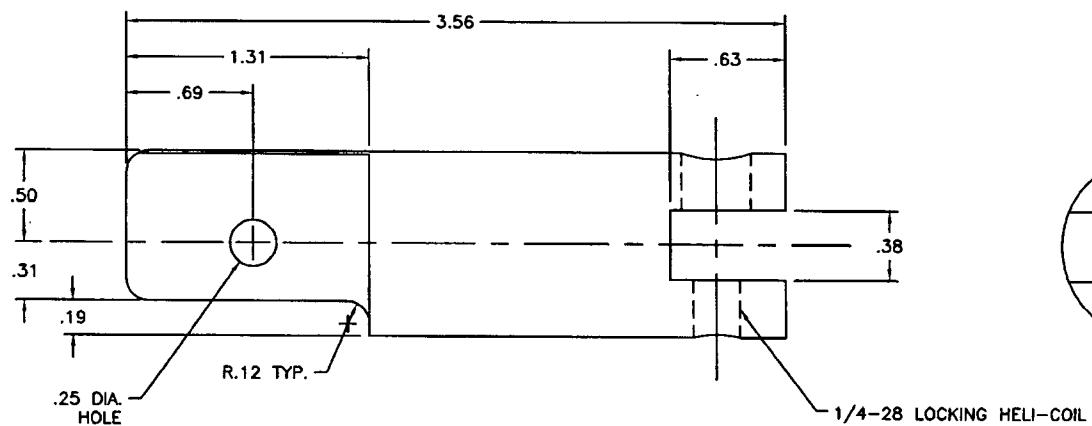
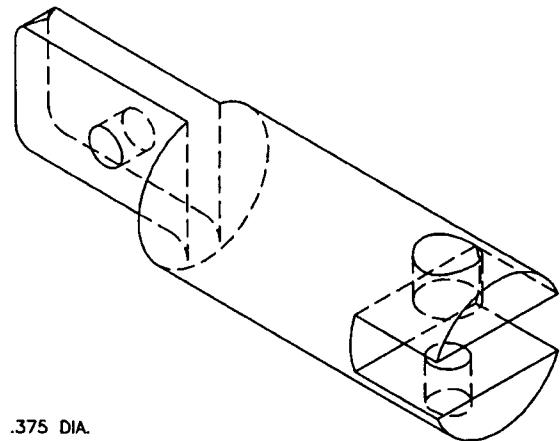
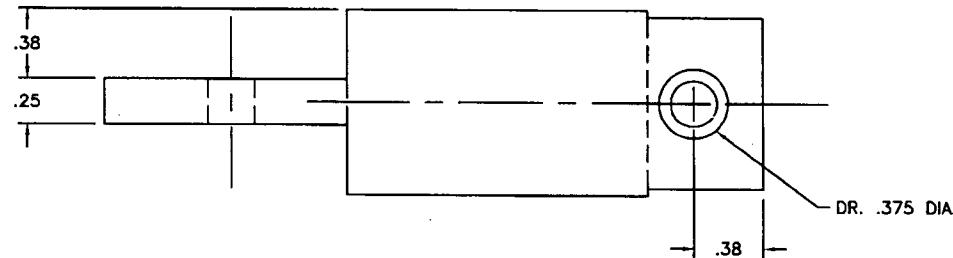
-003 LATCH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31773

PROPRIETARY RIGHTS NOTICE
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ERA Aviation, Inc.

TITLE		SIZE	DRAW. NO.	REV.
STEP ACTUATOR COMPONENTS	C	41232-200-002	SHT 2 OF 3	A



-005 PIVOT ARM

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31777

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TITLE		Era Aviation, Inc.	
STEP ACTUATOR COMPONENTS	C	REV. NO.	A

41232-200-002
SHT 3 OF 3

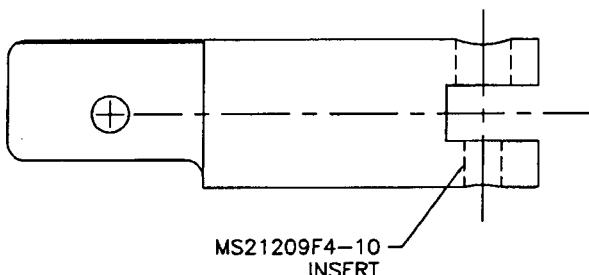
DATE 2/26/04	ENGINEERING ORDER		E.O. No. B-1	SHT. 1 OF 1
BY D. NELSON	TITLE STEP ACTUATOR COMPONENTS		DWG. AFFECTED 41232-200-002	
APPROVED BY			SHEET AFFECTED SHT 1 & 3	
REASON FOR CHANGE:	CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.			
MINOR CHANGE - FAR 21.95				

IS

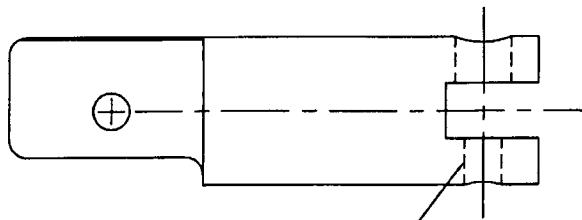
1	MS21209F4-10	INSERT
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WAS

1	MS21209F4-15	INSERT
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-005 PIVOT ARM



1/4-28 LOCKING HELI-COIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31777

CHANGE REQUIRED:	DATE:	BY:	YES	NO
TRAVELER				
INSTALLATION INSTRUCTIONS				
MAINTENANCE INSTRUCTIONS				
ILLUSTRATED PARTS				
UNINCORPORATED DRAWING LIST				
MASTER DRAWING LIST				
COMPUTER DATA BASE				

DART AEROSPACE LTD	Work Order:	31777
<i>Carb</i> Description: Crosstube Assembly Step Accelerator assembly	Part Number:	41232-2000-067-003
Inspection Dwg: 41232-2000-067 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SG/JL/JF	Audited by:	SA	Prototype Approval:	N/A
Date:	07/05/01	Date:	07.05.01	Date:	N/A

TNM**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / ISO 9001-2000 certified

Certifié NADCAP / NADCAP certified

**FACTURE
INVOICE****55027**

04-May-2007

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

**PURCHASE ORDER/
NO. DE COMMANDE:** **PO00003680****CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

ITEM NUMBER	COMMANDÉ ORDERED	EXPÉDIÉ SHIPPED	NUMBER & DESCRIPTION	PRÉT UNITAIRE UNIT PRICE	EXTENSION UNIT PRICE
1	26	26	VARIOUS	\$0.00	\$0.00
			LOT PRICE		\$130.00
				SUB TOTAL:	\$130.00
				TPS/GST:	\$7.80
				TVQ/PST:	\$0.00
				TOTAL AMOUNT DUE:	\$137.80

BLACK ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

No de TPS / GST # : 891559734 RT

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE

No de TVQ / QST # : 1019307154 TQ000

CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû à la valeur intrinséque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.